

# Work Order ID 82135

March-23-12 10:47:23 AM

**\*82135\***

Page 1

Item ID: D2932-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle RH Out, 206  
 Start Date: 23/03/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 06/04/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/23 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2932	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00  
**\*100\***  
 HAAS I Memo 0.00 FK 12/07/31 G  
 HAAS CNC vertical machine #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per PD

110 CONVENTIONAL MILLING MACHINE 0.00  
**\*110\***  
 Mill Conv Memo 0.00 FK 12/07/31 G  
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet PD

120 QC1- Inspect dimensions to dimension sheet 0.00  
**\*120\***  
 QC Memo 0.00 PD FK 12/07/31 G  
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*82135\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

\*6\*

**Cust Item ID:**

\*6\*

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

52 12/04/01

## Memo

0.00

## Quality Control

0.00

## Memo

0.00

6 PR 124.2

## Hand Finishing

0.00

## Memo

0.00

### Powdercoat

## Powder Coating

START TIME:

11610

OVEN TEMPERATURE:

m120222

11640 FINISH TIME:

320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Work Order ID 82135**

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Page 3

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Start Date: 23/03/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 06/04/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
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**\*160\***

QC

Memo

0.00

Quality Control

*JB* *PL 124-2*

170	Identify as per dwg & Stock Location: <i>428</i>	0.00							
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**\*170\***

Packaging

Memo

0.00

Packaging

*JB (6)* *12/04/03*

180	QC21- Final Inspection - Work Order Release	0.00							
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**\*180\***

QC

Memo

0.00

Quality Control

*MCJ* *12/04/03*

*12-04-3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

March-23-12 10:47:29 AM

Page 1

Work Order ID: 82135

\*82135\*

Parent Item: D2932-2

\*D2932-2\*

Parent Item Name: Saddle RH Out, 206

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC  
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	46.0000	1	6			

\*D6101-003\*

Saddle Billet, 7075

\*\*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	26	
73775	2	
73780	7	
78599	10	
MAT041	26	
79587	4	
80765	22	
MAT042	-7	
MAT044	1	
73769	1	

78159

2

FK 12/03/28

Didn't Pullout anything because  
Billet # 78159 is not in the computer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>82135</b>
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	<b>D2932-2</b>
<b>Inspection Dwg:</b> D2932 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.120	.120	.120	.120		
B	0.100	0.140		0.117	.120	.118	.118		
C	0.100	0.140		0.115	.118	.117	.117		
D	0.210	0.230		0.219	.219	.217	.217		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	.260	.260	.260		
L	0.312	0.317		0.313	.314	.314	.314		
M	0.235	0.240		0.236	.236	.236	.236		
N	0.100	0.140		0.123	.123	.122	.123		
O	0.540	0.560		0.550	.550	.550	.550		
P	0.490	0.510		0.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		0.250	.252	.252	.250		
T	0.100	0.180		0.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	.316	.316	.316		
X	1.125	1.145		1.132	1.1335	1.133	1.133		
Y	1.565	1.585		1.573	1.573	1.573	1.573		
Z	0.178	0.198		0.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <b>PD</b>	Audited by: <b>SL</b>
Date: <b>12/03/30 / 12/03/31</b>	Date: <b>12/04/01</b>

Measured by: <b>PD</b>	Audited by: <b>SL</b>
Date: <b>12/03/30 / 12/03/31</b>	Date: <b>12/04/01</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>82135</b>
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	<b>D2932-2</b>
<b>Inspection Dwg:</b> D2932 Rev. C		<b>Page 1 of 1</b>

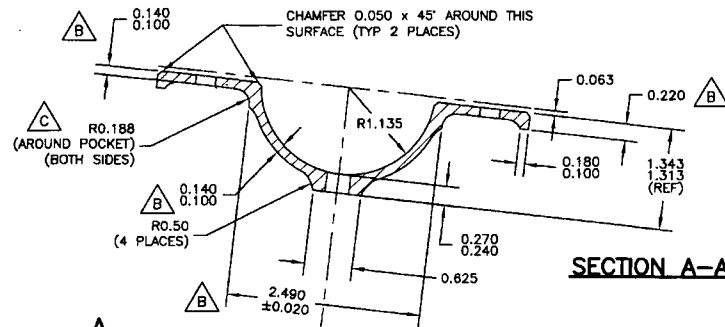
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

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Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.1335	1.133				
Y	1.565	1.585		1.5735	1.572				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

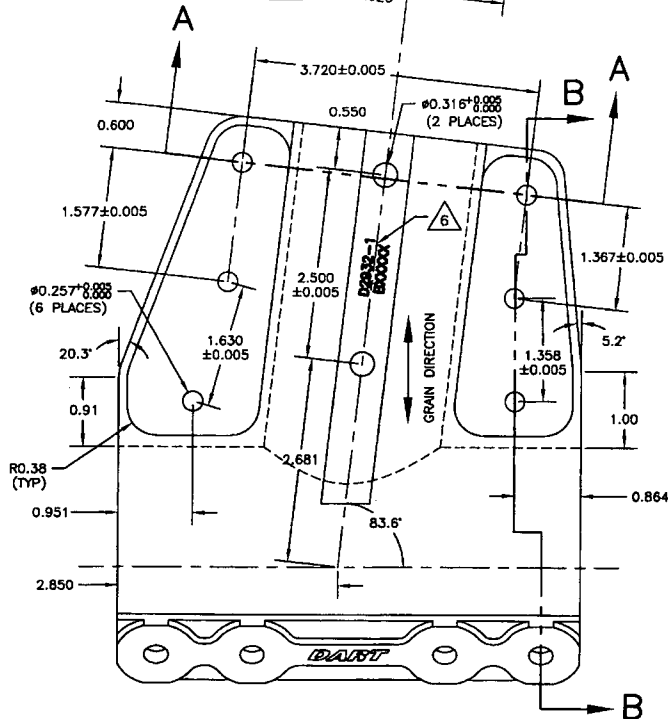
Measured by: <b>FK</b>
Date: <b>12/03/31</b>

Audited by: <b>Q</b>
Date: <b>12-04-01</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A

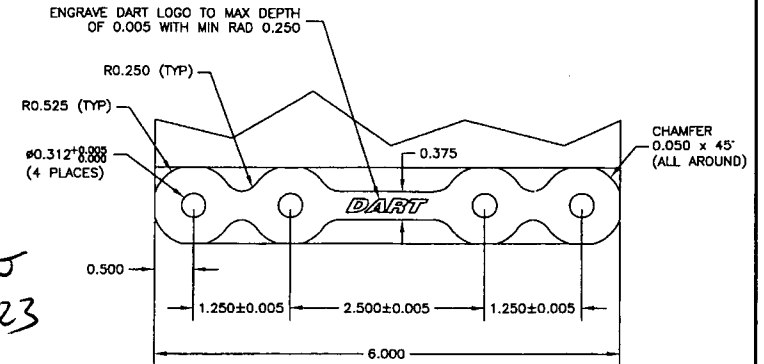
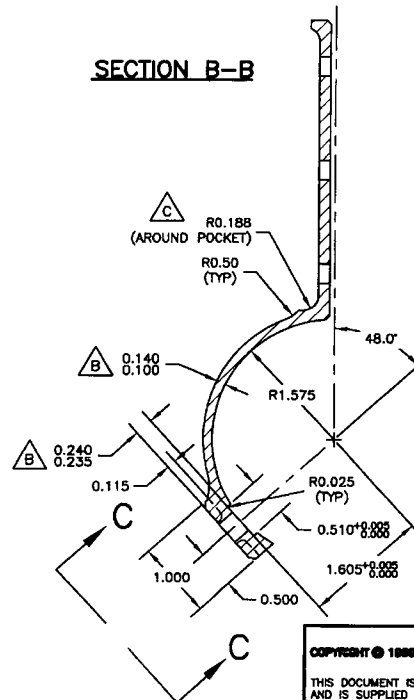


RELEASED  
07-02-12

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82135 MLJ

12/03/23

SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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DART AEROSPACE USA, INC.

**DART** DART AEROSPACE USA, INC.  
BELLINGHAM, WA

DESIGN NO. D2932  
REV. C  
SHEET 1 OF 1

SCALE

2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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